

Date: Thursday, 3/23/2006 3:39:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL LOCK 3 alike
 Job Number : 26339 2 unlike
 Estimate Number : 12342
 P.O. Number : N/A Part Number : D3368041
 This Issue : 3/23/2006 S.O. No. : N/A Drawing Number : D3368 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : N/A Material : N/A
 Due Date : 3/30/2006 Qty: 5 Um: Each
 Written By : SEE COMMENT Below
 Checked & Approved By : RJ 06.03.24
 Comment : Est Rev:A Removed from 9 Digit 06-03-22 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33681 Pedal Lock Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3368-1 BASE B22940 B22939 ✓

2.0 D33683 Pedal Lock Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3368-3 COVER B22940 ✓

3.0 D27287 Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Decal B22554 ✓

4.0 D33737 Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3373-7 Cam Lock B22416

② 22292 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number: 26339

Part Number: D3368041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33853

Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3385-3

Hinge

~~B22387~~

B22387 ✓

6.0

238028

3/16" Dowel Pin .5" long



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 238-028

Ø3/16" Dowel Pin 1/2" long

117843 ✓

7.0

385039

8-32 Flat screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 385-039

Flat Head Screw

M17356

SB

06/03/03

5

8.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3384-1

Cyclic Sock

2 B22390

SB

06/04/03

2

9.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CBL-460

Loop Sleeve

M19476

2

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

CBL1240

Cable



Comment: Qty.: 2.3333 f(s)/Unit Total : 11.6665 f(s)

Pick:

Qty Part Number Description Batch

28" CBL-1240 Cable M 16713

11.0

AN960416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer M 5519

12.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long M 16971

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel.
Discard the rest.

2-Fabricate D3371-5 Cam Lock as per Dwg D3371 Identify as D3371-5

3-Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Ensure mechanism works properly (open/close).

Pick:

Qty Part Number Description Batch

A/RN/A 262 Locktite B 16507

4-Assemble lanyard to cyclic sock as per Dwg D3384

5-Assemble D3384-047 to D3368-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3368

6-Ensure that keys are attached to D3368-041

SB 06/04/03

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/04/10
 QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC5

INSPECT WORK TO CURRENT STEP



06-04-04

*3 KA
2 KD*

Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

04/4/6 (5)

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/10 (5)

Job Completion



U 06-06-06

*clake
un alike*

Keys

#

3 are

C420A

Keys

#

C266A

C178A

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

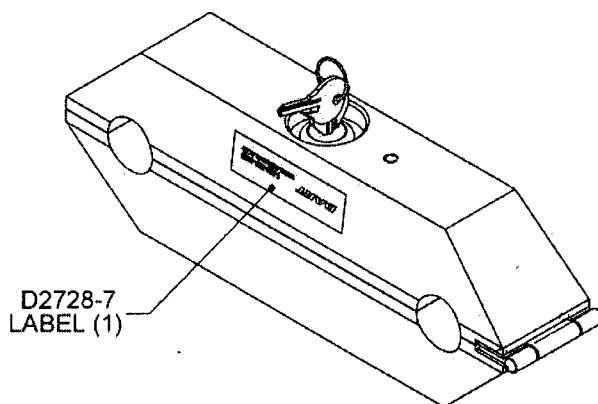
QA: N/C Closed: _____ Date: _____

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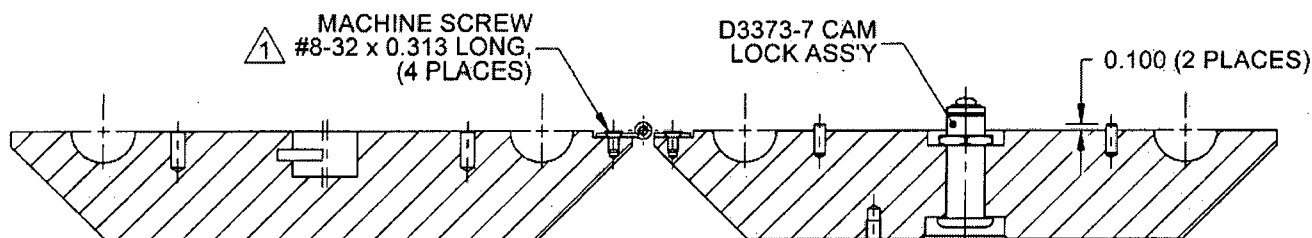


DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

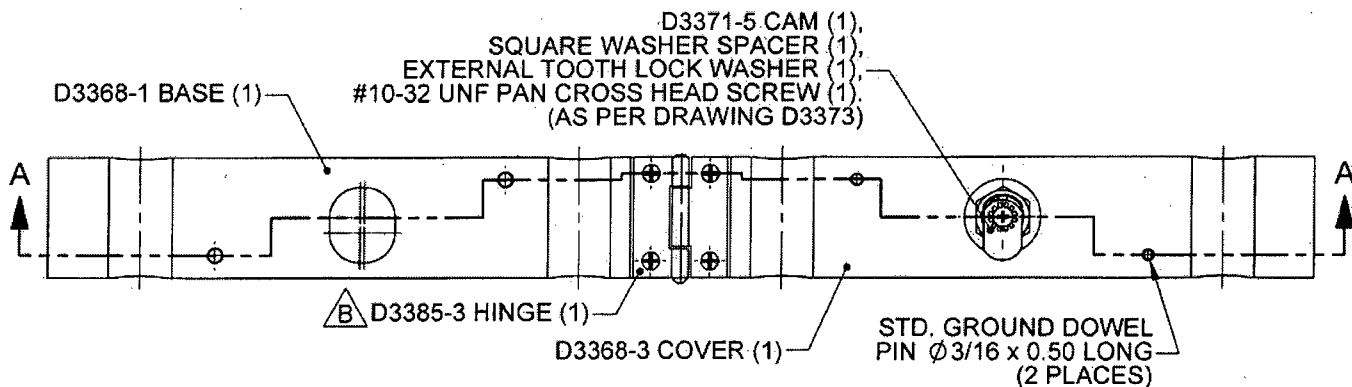


RELEASED
[Signature]
25/04/28

PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. **26339**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

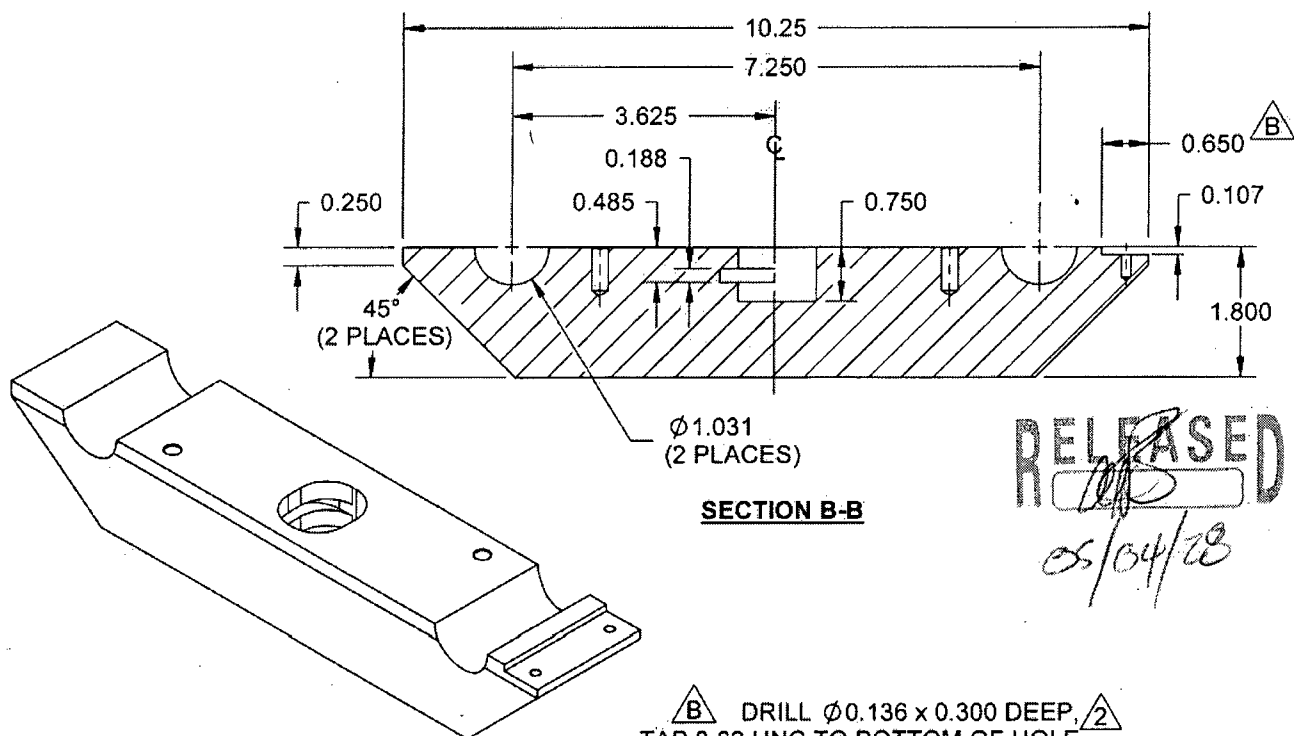
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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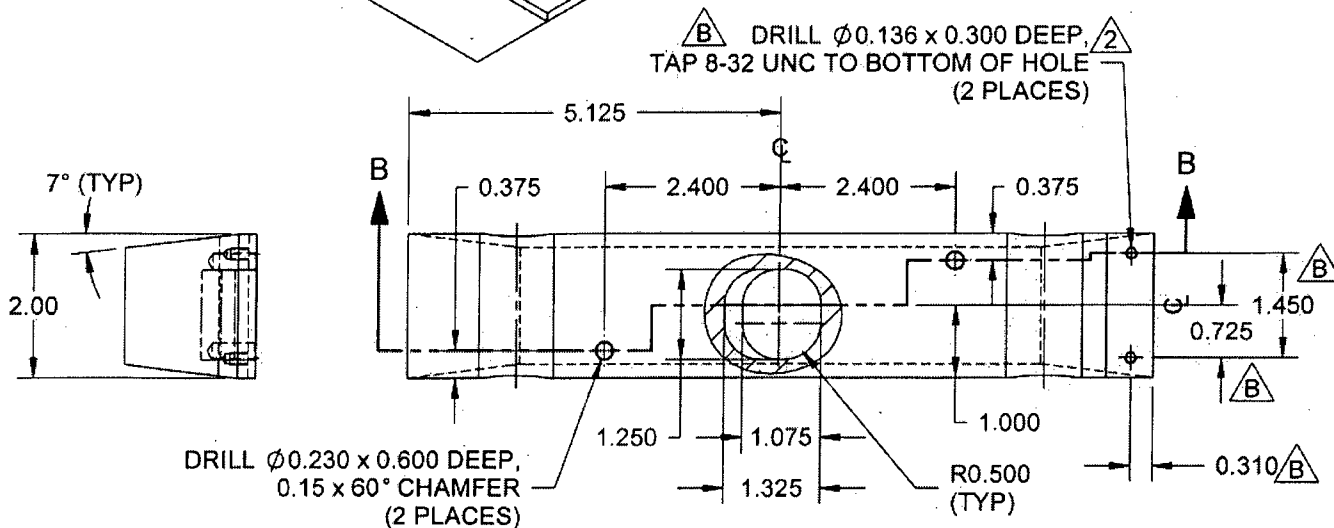
NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



RELEASED
05/04/28



D3368-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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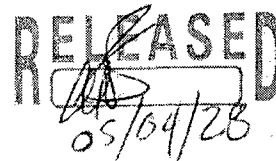
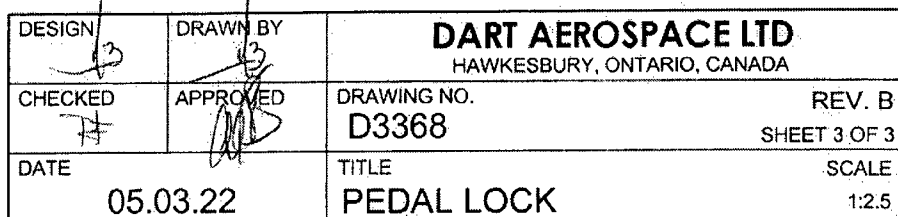
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